

Date: Wednesday, 10/3/2007 8:42:30 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 STEP LUG
Job Number	: 34993		
Estimate Number	: 11844		
P.O. Number	: <i>N/A</i>	Part Number	: D23382
This Issue	: 10/3/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2338 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 31210	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/20/2007
Checked & Approved By	: <i>[Signature]</i> 07.10.03	Qty:	10 Um: Each
Comment	: Est. B 00.03.24 Separated -1 from -2 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 0.3827 f(s)/Unit Total : 3.0618 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6 0.5 x 6.0"
 Batch: *M105145X*
 1 blank makes one D2338-1 & one D2338-2

J.L 07/11/13

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut Blanks 8.75" long

J.L 07/11/13

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2338
 Tumble & Deburr

S.F 07/11/14 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.F 07/11/14 (10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

B.G 07.11.15 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:42:30 AM

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Drawing Name: 204 STEP LUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WAPAC*

SE 07.11.19

10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10) DOLU/R

Job Completion



U 07.11.19

11/11/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

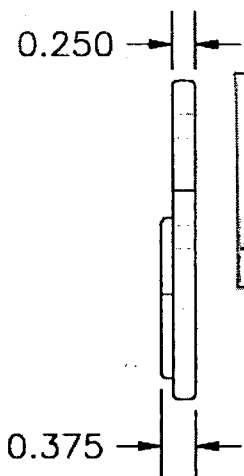
NOTE: Date & initial all entries



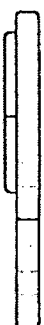
DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2338	SHEET 1 OF 1
DATE	95:01:25	TITLE	ENDPLATE	SCALE	1:2
B	96.03.29	RE-DESIGN AND ADD D2338-2			

RELEASED
97/04/22 DS

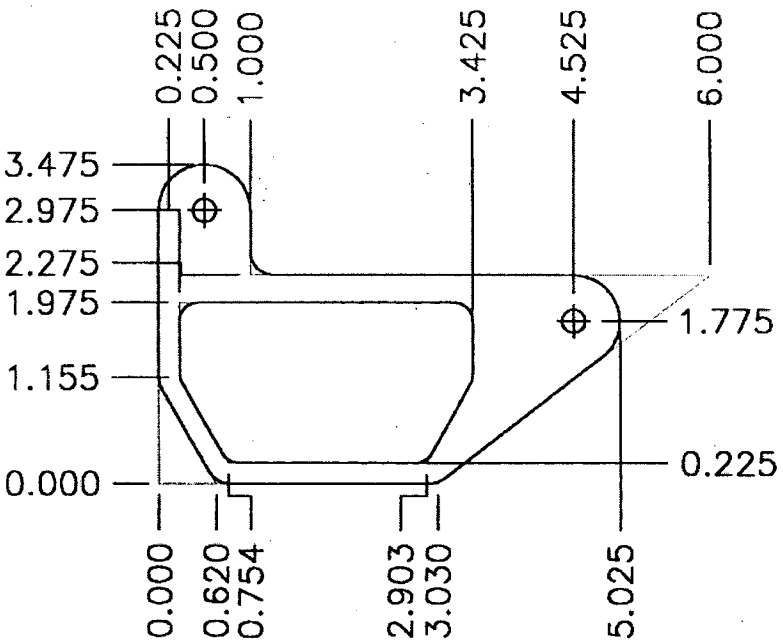
UNDER REVIEW
02.11.11



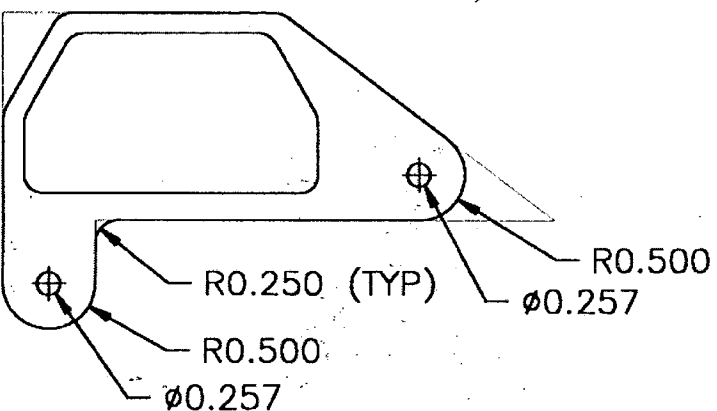
D2338-1



D2338-2



NOTE: BREAK ALL EDGES R0.063 MAX



MATERIAL: 6061-T6, 0.25 THICK

DART AEROSPACE LTD		Work Order: 834993
Description: 204 step lug		Part Number: D233R-2
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.975	$\pm .010$	1.977	✓			
.225	$\pm .010$.222	✓			
2.275	$\pm .010$	2.279	✓			
3.475	$\pm .010$	3.478	✓			
.225	$\pm .010$.227	✓			
.500	$\pm .010$.498	✓			
1.000	$\pm .010$	1.001	✓			
3.425	$\pm .010$	3.428	✓			
4.525	$\pm .010$	4.528	✓			
5.025	$\pm .010$	5.028	✓			
.250	$\pm .010$.249	✓			
.375	$\pm .010$.371	✓			
Ø .257	$\pm .006 - .001$.262	✓			
R .500	$\pm .010$.500	✓			
R .250	$\pm .010$.250	✓			

Measured by: S.F
Date: 07/11/14

Audited by: [Signature]
Date: 07/11/14

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	